

Work Order ID 151986

Friday, October 14, 2016 1:56:35 PM

151986

Page 1

Item ID: D3847-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 11/4/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/9/2016 Req'd Qty: 4.00

4

Customer:

Reference:

DAS
21Approvals: Process Plan: 9-89 Date: OCT 17 2016

Tooling:

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3847	D
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100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3847

Dwg Rev: DProg Rev: D

2-Deburr if necessary

0.03

(4)

De 16/10/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

(4)

De 16/10/22

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Item ID: D3847-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 11/4/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/9/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
193		0.00							DAS 41 9-89
193						4			
HandFinish	Memo	0.00							16-11-5
Hand Finishing	APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG								
	TEXTURE COATING BATCH: <u>135403</u>								
196	QC3- Inspect Part Finish	0.00							DAS 38
196						4			NOV 07 2016
QC	Memo	0.01							
Quality Control									
200	Identify as per dwg & Stock Location: _____	0.00							
200									DAS 6 9-89
Packaging	Memo	0.01							NOV 08 2016
Packaging	LOCATION ; FP001								

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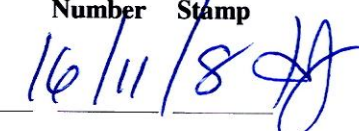
151986

Page 5

Item ID: D3847-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 11/4/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/9/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.07							
Quality Control									

16/11/8 
 16-11-8

Picklist Print

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Work Order ID: 151986

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Parent Item: D3847-11

D3847-11

Parent Item Name: Wearpad

Start Date: 11/4/2016

Required Date: 11/9/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

IPP REV:B

16.03.31 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	94.8700		0.712842			

M304S16GA

304/316 Sheet .063

Re 16/10/22

Location

Loc Qty

Loc Code

MAT010

94.87

m135377

28.42

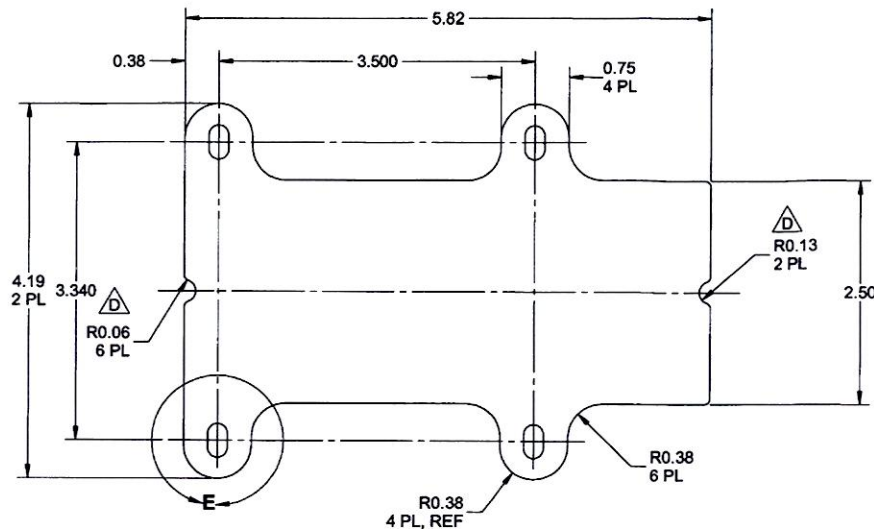
m135559

2.45

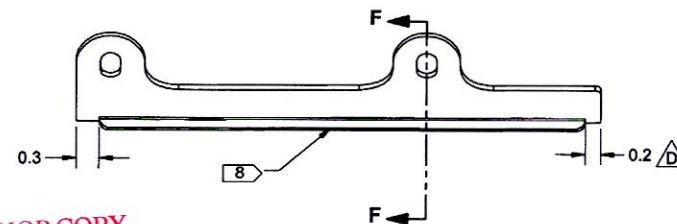
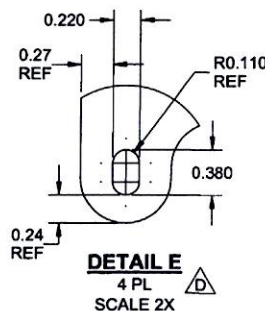
m135689

64

7

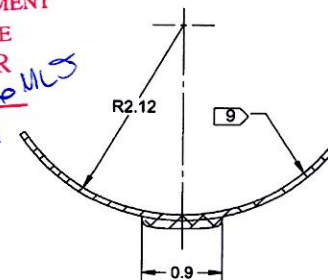


D3847-11F WEARPAD
(FLAT PATTERN)



D3847-11 WEARPAD
(MAKE FROM D3847-11F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 151986 WLS
1670-17



SECTION F-F

NOTES:

- 1) MATERIAL -11F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.43 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2016-03-31

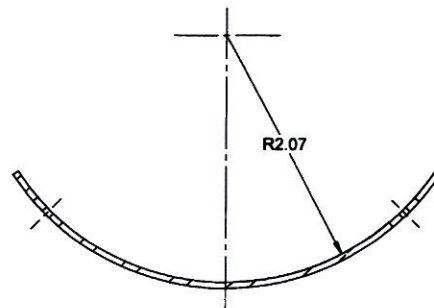
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DESIGN	RF
DRAWN	AJS
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	15.09.28

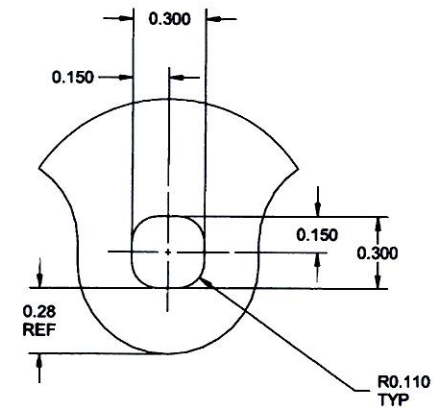
DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D3847** REV. D
SHEET 2 OF 7
TITLE **WEARPLATE ASSY** SCALE NTS

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SECTION C-C C3-2
SCALE 4X C4-3
C3-4
C2-5



DETAIL D B5-2
SCALE 4X B6-3
B3-4
B4-5

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